

Date: Wednesday, 4/19/2006 7:36:58 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 26710	
Estimate Number : 11481	
P.O. Number : N/A	Part Number : D31462
This Issue : 4/19/2006 S.O. No. : N/A	Drawing Number : D3146 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>See A Comment Below</u>	Due Date : 5/5/2006 Qty: 10 Um: Each
Checked & Approved By : <u>06.04.19</u>	
Comment : Est A04.04.28 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X04500	6061-T6 Bar 1.25" X 4.5"
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Comment: Qty.: 0.2931 f(s)/Unit Total : 2.9306 f(s)
Material: 6061-T6/T651 (QQ-A-200/8) 1.250" thick
(M6061T6B1.250x04.500)
Identify for D3146-1
Batch: 171655

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blanks: 4.500" x 1.250" x 3.100" long Bar

SA 06.04.27 x4
EN 06/04/25 x10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA419 and Dwg D3146
Identify as D3146-2

SA 06.04.27 11

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 06.04.27 11

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 06/05/01 11

P10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/27	3	- Part 1: fitted while machining. (1 part)		- fix jaws so they close properly replace Scrap Edson part	SD 06.04.27	 06.05.01		 06.05.01

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 26710

Part Number: D31462

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr and Tumble

J.L 06/05/01 (11)

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

9-m 06-05-01 (11)

8.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/05/01 (11)

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-05-02 (11)

10.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

N/A

11.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST410

A 06/05/02 (11)

12.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
Inspection Level 21

06/05/02 (11)

Job Completion



U 06.05.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26710
Description: Bracket		Part Number:	D3146-2
Inspection Dwg: D3146 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.000	+/-0.010	3.004	/			
2.000	+/-0.010	2.000	/			
0.230	+/-0.010	.234	/			
0.425	+/-0.010	.430	/			
3.420	+/-0.010	3.424	/			
2.535	+/-0.010	2.535	/			
0.221	+/-0.010	.218	/			
0.391	+/-0.010	.385	/			
0.221	+/-0.010	.218	/			
0.850	+/-0.010	.854	/			
R0.350	+/-0.010	R.350	/			
0.850	+/-0.010	.854	/			
0.221	+/-0.010	.218	/			
0.491	+/-0.010	.485	/			
0.125	+/-0.010	.129	/			
1.025	+/-0.010	1.025	/			
R0.375	+/-0.010	R.373	/			
28°	+/-0.1°	28°	/			
0.276	+/-0.010	.276	/			
0.925	+/-0.010	.925	/			
R0.125	+/-0.010	R.125	/			
4.345	+/-0.010	4.350	/			
0.125	+/-0.010	.129	/			
93°	+/-0.1°	93°	/			
R0.125	+/-0.010	R.125	/			
Grain Direction	N/A					

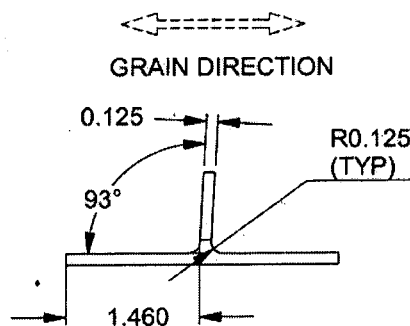
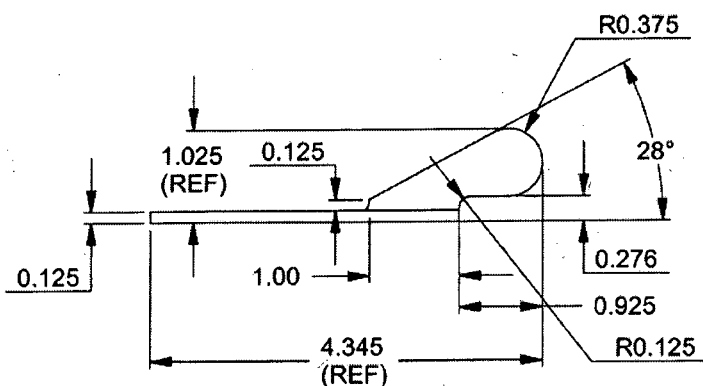
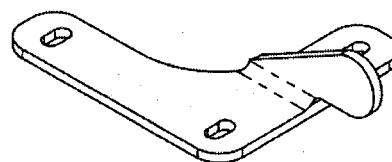
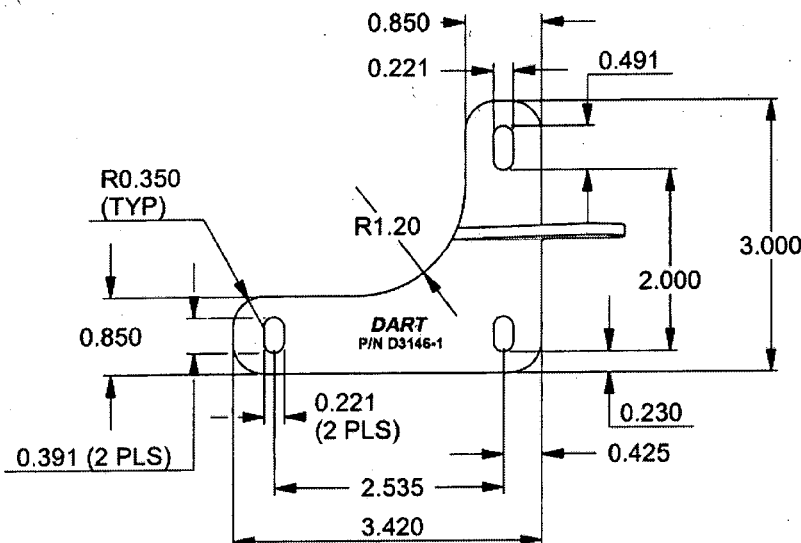
Measured by: SD	Audited by: J.G	Prototype Approval:	N/A
Date: 06-04-27	Date: 06/04/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3146	REV. A SHEET 1 OF 1
DATE 02.04.25	TITLE BRACKET	SCALE 1:2	
A	02.04.25	NEW ISSUE	

RELEASED
02.05.27



D3146-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-27
(D3146-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-28)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 26710

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